

Date: Wednesday, 3/26/2008 9:33:24 AM
User: Kim Johnston

Process Sheet

WK15

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")
Job Number : 38142	
Estimate Number : 10972	
P.O. Number :	Part Number : D130700011
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D3167 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 36584	Material :
Written By :	Due Date : 4/10/2008 Qty: 5 Um: Each
Checked & Approved By : <u>JLD 08.3.26</u>	
Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM	
Est Rev:K 08-01-09 Added Step 2 JLM Verified	
By:EC	

No Mat.

Additional Product

Job Number:



Seq. #	Machine Or Operation	Description
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D130-700-011CHG001

S 08/06/10 8.4.24 JLD

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: MFG ENGINEERING

Program Batch Number

Per 08-05-28

3.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 7.1610 sf(s)/Unit Total : 35.8050 sf(s)

blank: 20.00" x 24.00" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"

(MUHMWB10)

Batch: *M 108013*

B.A 08/06/04

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA285 and Dwg D3167

3-Deburr

FA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:33:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 38142

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA ✓

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/06/10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

8.0

D2182

Heat Shrink



Comment: Qty.: 2.0000 f(s)/Unit Total : 10.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B060 Rubber Cushion

35769

~~This Batch once again has been entered.~~

CUT 6.00" LONG

J.S 08/06/10 (XS)

9.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

B37630x48

2 D2432F(ref only)

Bearpaw

B39238x12

J.S 08/06/10 (XS)

10.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2519

Clamp

B37852

B34306

J.S 08/06/10 (XS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 38142

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

B37210

AS 08/06/10 (XS)

12.0

D31711

Angle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D3171-1

Angle

B18591 X5

B38176 X15

AS 08/06/10 (XS)

13.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-12A

Bolt

M105143

AS 08/06/10 (XS)

14.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M167737

AS 08/06/10 (XS)

15.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M107939

AS 08/06/10 (XS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: BEARPAW KIT (19"X24")

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Part Number: D130700011

Job Number:



Seq. #

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M107478

AS 08/06/10 (XS)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/06/10 (XS)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-700-011

Location:

Rev A

AS 08/06/10 (XS)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/11 AS

Job Completion



u 08.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38142
Description: Bearpaw		Part Number: D3167-1
Inspection Dwg: D3167	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.06 x 45°	/		
B	5.80	+/-0.030	5.80	/		
C	0.25 x 45°	+/-0.030	0.25 x 45°	/		
D	R0.25	+/-0.030	R.25	/		
E	0.200	+/-0.030	.200	/		
F	0.250	+/-0.010	.245	/		
G	0.625	+/-0.030	.620	/		
H	0.375	+/-0.010	.374	/		
I	0.950	+0.030/-0.010	.951	/		
J	3.21	+/-0.030	3.21	/		
K	19.00	+/-0.030	19.00	/		
L	Ø0.260	+0.005/-0.000	Ø.260	/		
M	Ø0.93	+/-0.030	Ø.928	/		
N	0.30	+0.030/-0.000	.315	/		
O	0.375	+/-0.030	.375	/		
P	7.23	+/-0.030	7.23	/		
Q	4.54	+/-0.010	4.54	/		
R	2.00	+/-0.030	2.00	/		
S	12.000	+/-0.010	12.003	/		
T	6.000	+/-0.010	6.000	/		
U	23.75	+/-0.030	23.75	/		

Measured by: SA	Audited by: J.F.	Prototype Approval:	N/A
Date: 08/06/06	Date: 08/06/06	Date:	N/A

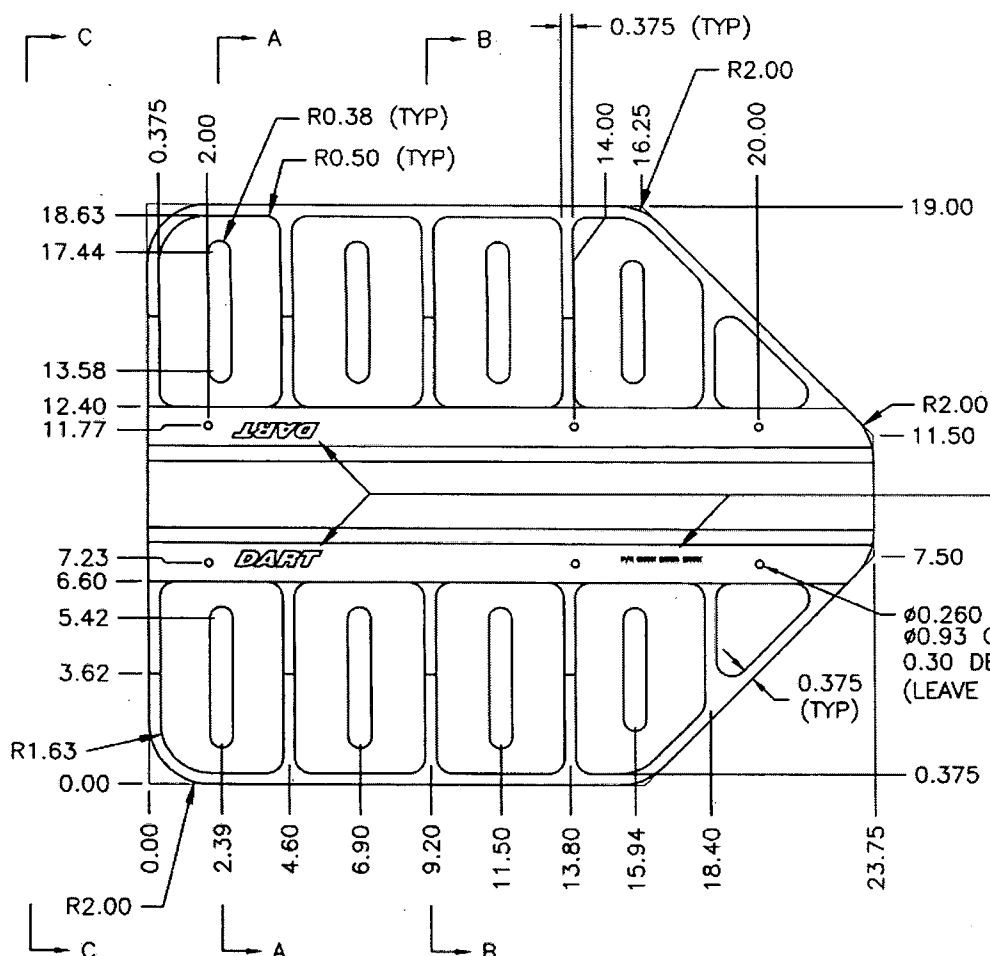
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	#



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		HAWKESBURY, ONTARIO, CANADA	
02.10.08		BEARPAW		REV. A	
A		02.10.08		SHEET 1 OF 2	
A1		02.12.17		SCALE	
		5.80 WAS 5.50		1:6	
		NEW ISSUE			

RELEASED
02.10.25-47

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



D3167-1

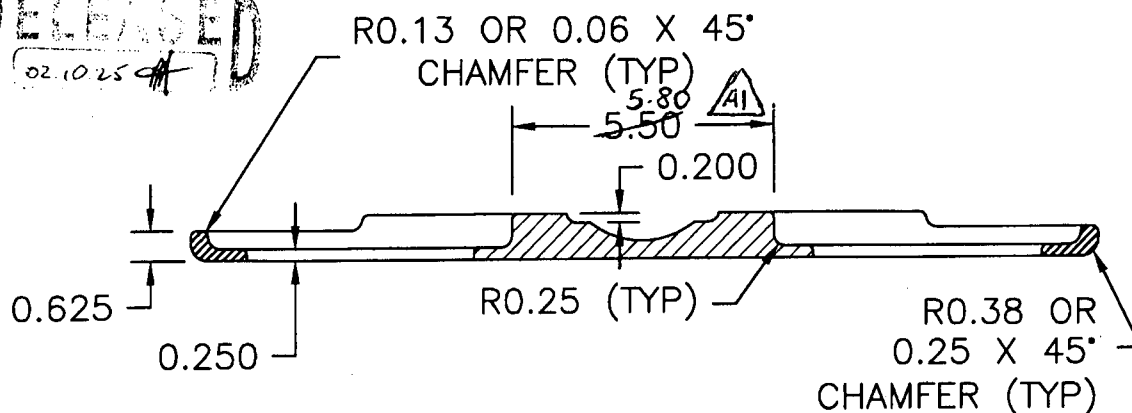
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 38142

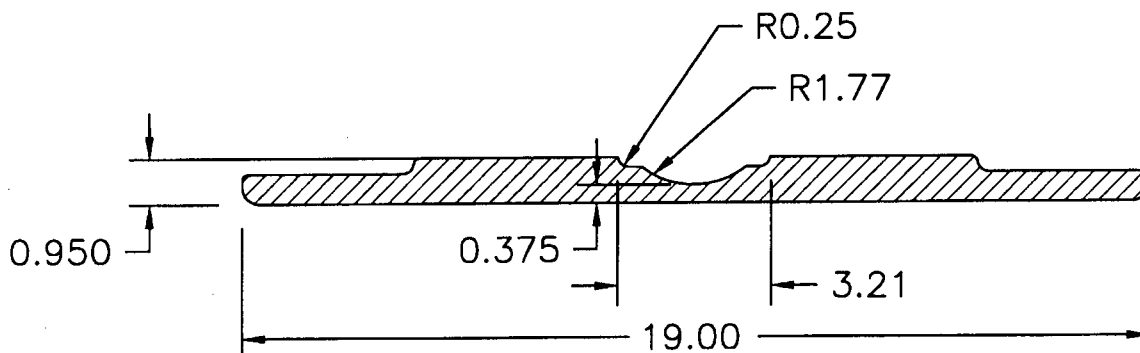


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CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

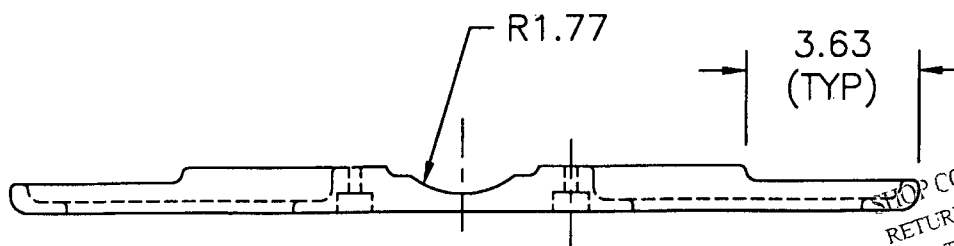
RELEASED
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

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WORK ORDER
NO. 38142

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